



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3488-3

Job Sheet 186362



Part No: D3488-3

Job Qty: 10 ea

Part Name: Blade Fitting, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/14/18

Job Tracking No:

Due Date: 11/19/18

Created By: Jesse White

Type: SOLD

Description:

Note: DSK101 REV.D / D3488 REV.C IPP REV:A 18.11.09 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	11/19/18	11/19/18	0.00	0.00	Start Up Machining-2		
100	Doosan	10 pcs	11/19/18	11/19/18	0.00	8.79	Doosan		
110	QC	10 pcs	11/19/18	11/19/18	0.00	0.00	QC2 Machining-2		
120	CNC Vertical Machining	10 pcs	11/19/18	11/19/18	0.11	6.86	HAAS1-3		
130	QC	10 pcs	11/19/18	11/19/18	0.00	0.00	QC2 Machining-2		
140	QC	10 pcs	11/19/18	11/19/18	0.00	0.00	QC8 Machining-2		
150	HandFinish	10 pcs	11/19/18	11/19/18	0.00	0.30	HandFinish1		
160	Powdercoat	10 pcs	11/19/18	11/19/18	0.00	0.35	Powdercoat1		
170	QC	10 pcs	11/19/18	11/19/18	0.00	0.00	QC3		
200	Packaging	10 pcs	11/19/18	11/19/18	0.00	0.00	Packaging3-1		
210	QC21-SA	10 Ea	11/19/18	11/19/18	0.00	0.00	QC21		

Part Op 100 - 1-Turn as per Dwg DSK 101 & Folio FC491

Descriptions: 120 - 1-Machine as per Folio FA627 & Dwg D3488

160 - START TIME: 1:00 OVEN TEMPERATURE: 300° FINISH TIME: 1:50

200 - LOCATION : FP001

21
9-89

DEC 11 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6103-003	Round Billet, Aluminum	10 Ea (1 ea)	90-Start up Operation	566454 X9 5093830 X1

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6103-003	10	43	0

Part Specifications

Specifications could not be found.

Plex 11/14/18 2:12 PM dart.white.jesse

✓
040

25

25

DART AEROSPACE LTD		Work Order: 180362
Description: Blade Fitting, LH / Turning Detail for D3488-1/-2		Part Number: D3488-3
Inspection Dwg: D3488 / DSK101 Rev: 		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
Ø2.150	REF	2.151				OK
Ø2.780	+/-0.005	2.7785				OK
Ø3.125	+/-0.010	3.123				OK
Ø3.346	+/-0.010	3.343				OK
0.125 x 45°	+/-0.010 x +/-0.1°	.130 140°				OK
8.000	+0.030/-0.000	8.013				OK
9.250	+/-0.010	9.250				OK
0.188	+/-0.010	.187				OK
R0.032	+/-0.010	R.032				OK
R0.062	+/-0.010	R.062				OK
Ø0.207	+0.005/-0.001					
2.315	+/-0.005	2.314				OK
2.200	+/-0.01	.198				OK
2.620	+/-0.010	2.620				OK
2.500						
1.005						
Ø0.484	+0.005/-0.001	.485				OK
1.180	+/-0.010	1.179				OK
3.150	+/-0.010	3.149				OK
3.070	+/-0.010	3.067				OK
R0.063	+/-0.010	R.063				OK

DART AEROSPACE LTD		Work Order: 186362
Description: Blade Fitting, LH / Turning Detail for D3488-1/-2		Part Number: D3488-3
Inspection Dwg: D3488 / DSK101 Rev C/D		Page 2 of 2

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Milling Section						
Ø0.508	+0.006/-0.001	0.5085	✓		G.P.	
0.750	+/-0.010	0.750	✓			
1.500	+/-0.010	1.500	✓			
11.18	+/-0.030	11.182	✓			
R0.062	+/-0.010	0.062	✓			
0.125	+/-0.010	0.129	✓			
0.590	+/-0.010	—	—	—	—	—
0.793	+/-0.010	0.798	✓			
1.351	+/-0.010	1.348	✓			
1.317	+/-0.010	1.325	✓			
1.802	+/-0.010	1.802	✓			

Measured by: [Signature]	Audited by: [Signature]	Prototype Approval:	N/A
Date: 18/11/14	Date: 18/12/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	
B	08.09.19	Reformat P/O D3488-041	KJ/JLM	
C	08.12.02	Dimension 8.000 removed	KJ/JLM [Signature]	[Signature]

DART
AEROSPACE

1210 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S128414



Part: D3488-3

Job No: 186362

Serial No/Batch: S128414

Revision: D/C

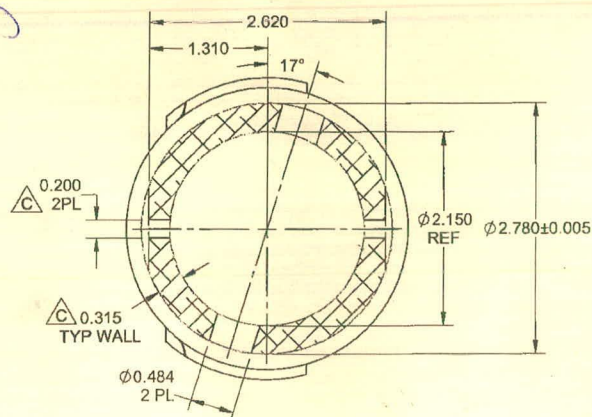
Inspector:

Exp Date:

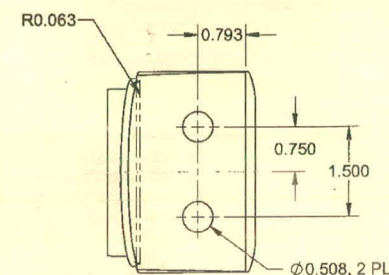
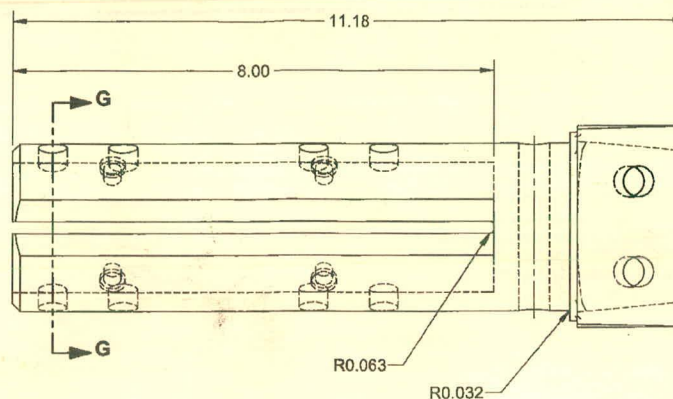
Instructions:

Date: 11/16/18

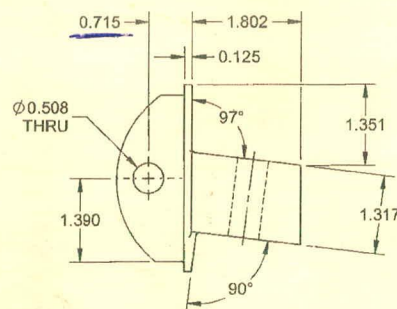
Handwritten marks at top right corner.



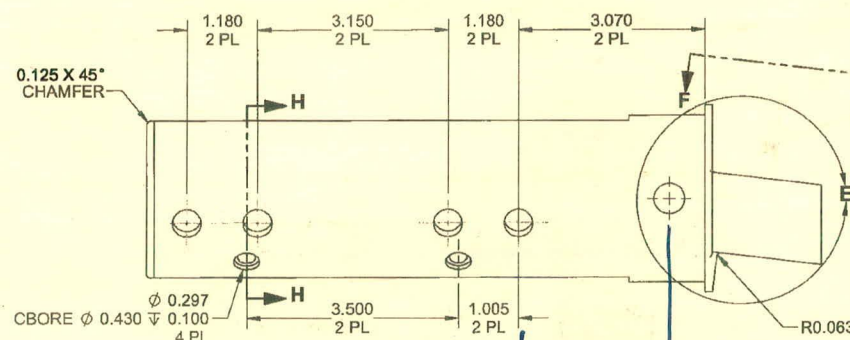
SECTION G-G
SCALE 1.25X, 4 PL



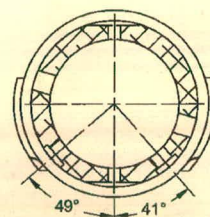
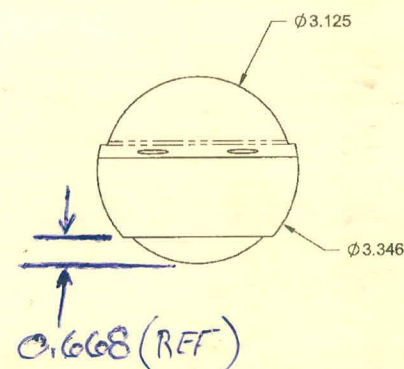
VIEW F-F



DETAIL E



D3488-2 BLADE FITTING, RH



SECTION H-H
2 PL

NOTES:

- 1) MATERIAL: 7075-T73 (OR 7075-T7351/T73510/73511) ROUND BAR PER AMS-QQ-A-200/11 OR AMS-QQ-A-225/9 REF DART SPEC. M7075T73R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.7
- 7) WEIGHT: 3.3 lbs

RELEASED
2018 OCT 19

Important

APPROVED

DESIGN	AJS	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. C
MFG. APPR.	DD	D3488	SHEET 3 OF 5
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	BLADE FITTING	NTS
DATE	18.03.07	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC.	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

